

Work Order ID 99542

April-11-13 11:05:57 AM

99542

Page 1

Item ID: D2221

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 350 Basket Base

Stop

NS2

Start Date: 4/11/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 13-04-11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								

100 0.00

100

Large Fab

Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221

3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 124816

(1)
PL 13-4-18

PLEASE NOTE SEE DWG

IF MAKING -141-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-
043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER
DWG

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00

Quality Control

13-04-18 09 DAS

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NS1

Revision ID:

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Stop

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Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120*	QC6- Inspect dimensions to drawing	0.00							DAS 09

QC

Quality Control

125	Pressure Wash per QSI005 4.3	0.00
-----	------------------------------	------

125

HandFinish

Hand Finishing

Memo

0.00

1 NG 13-4-18

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Item ID: D2221

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N900040100

Setup Start

NS1

Revision ID:

Item Name: 350 Basket Base

Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

130

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to

8:40 01=

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:10 40 01=

9:15 40 01=

9:45

140

QC3- Inspect Part Finish

0.00

Memo

0.00

140

QC

Quality Control

LX, YM/L 13/04/19

W125069

1 6 134-22

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Page 4

Item ID: D2221

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 350 Basket Base

Stop

NS2

Start Date: 4/11/13 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 4/25/13 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

150

Identify as per dwg & Stock Location

D350-600-00-041

99541

150

Packaging

Memo

0.00

1

Ø

BL13-422

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

13

4

13/4/23

160

QC

Quality Control

Memo

0.00

13/04/23

Picklist Print

April-11-13 11:06:00 AM

Work Order ID: 99542

Parent Item: D2221

Parent Item Name: 350 Basket Base

99542
D2221

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Picklist Print

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Work Order ID: 99542

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

49.0000

2

2

**

D2232-3

Basket Hinge

GCL13-4-18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	5	
97261	5	
WA004	44	
75581	2	
98040	22	(2)
98473	20	

D2235-1

Manufactured No

100

Each

13.0000

2

2

**

D2235-1

Basket Rib

GCL13-4-18

397035 → (2)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	9	
66895	4	
85602	4	
86051	1	
WA005	4	
96126	4	

Picklist Print

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured

No

100

Each

90.0000

2

2

**

PCL13.4.18

D2581

Mounting Bracket

Location	Loc Qty	Loc Code
WA	58	
96599	14	
98503	44	
WA004	32	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	
87706	2	
98108	20	

D3442-1

Manufactured

No

100

Each

13.0000

2

2

**

PCL13.4.18

Shim

Location	Loc Qty	Loc Code
WA	13	
98076	13	

D3825-041

Manufactured

No

100

Each

2.0000

2

2

**

PCL13.4.18

D3825-041

Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA004	2	
97285	2	

398491 → ②

Picklist Print

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

D3826-041

Manufactured No

100

Each

6.0000

2

2

**

✓ *D3826-041*

Rib / Gusset Assembly

CPL 13.4.18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004 98092	4	
WA006 98344	2	

(2)

D3827-041

Manufactured No

100

Each

2.0000

1

1

**

✓ *D3827-041*

Rib Assembly (Inboard)



CPL 13.4.18

398452 → (1)

D3832-1

Manufactured No

100

Each

9.0000

1

1

**

✓ *D3832-1*

Mesh (Base)

CPL 13.4.18

(1)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA 87142	9	
96614	6	
98291	2	
	1	

Picklist Print

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Work Order ID: 99542

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

D3833-1

Manufactured No

100

Each

32.0000

2

2

**

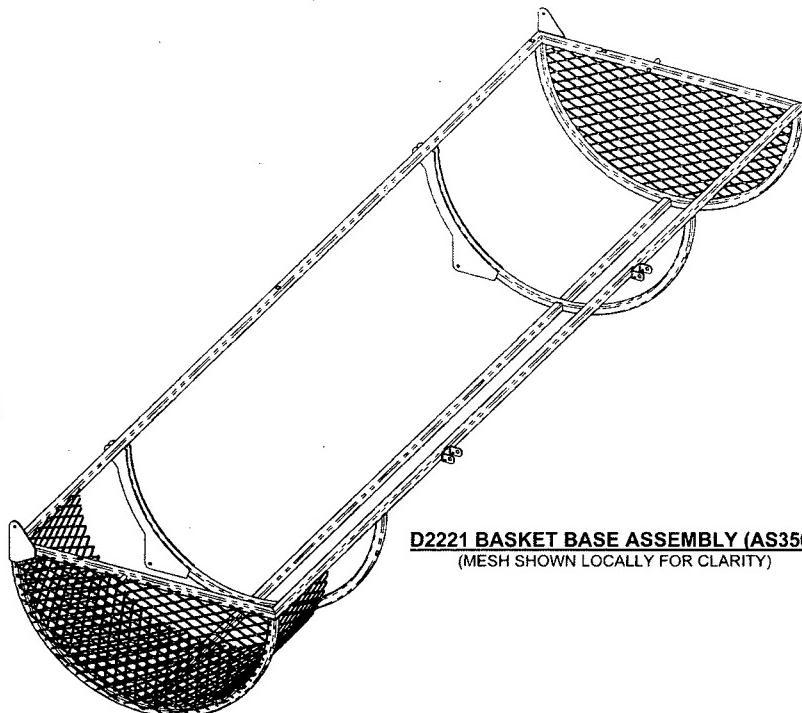
CPL 13-4-18

D3833-1

Mesh (Base End Face)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	18	
	98359	(1)
	99268	
WA007	6	
	12	
	14	
77521	4	
81259	1	
89208	1	
98538	8	(1)

H	ITEM	QTY	P/N	DESCRIPTION
1	X	D2221		BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB	
3	2	D2221-5	RIB	
4	1	D2221-7	RIB	
5	2	D2232 3	BASKET HINGE	
6	2	D2235-1	RIB	
7	2	D2581	MOUNTING BRACKET	
8	2	D3442-1	SHIM	
9	2	D3825-041	RIB ASSY (BASKET END)	
10	2	D3826-041	RIB/GUSSET ASSY	
11	1	D3827-041	RIB ASSY (INBOARD)	
12	2	D3833-1'	MESH, BASE END FACE	
13	1	D3832-1	MESH (BASE)	



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITH CHANGES

VIA CHANGER

NO 99542 MC5

RE
08/11/11

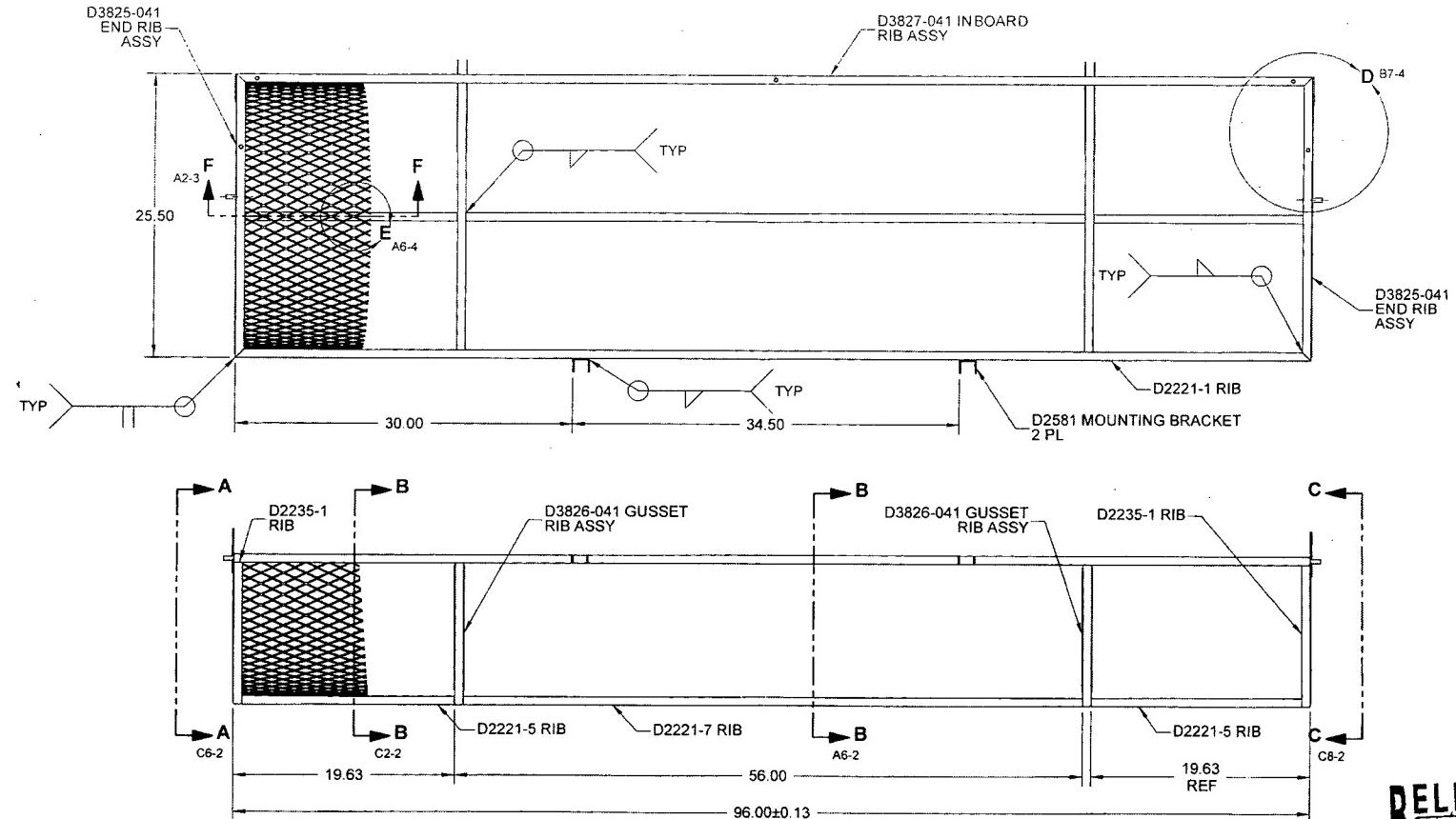
13-04-11

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED SECTION G-G (ZN B4-1); ADDED SECTION H-H (ZN B5-1); REVISED TOL 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D235; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY LEAN MANUFACTURING PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>AM</i>	D2221	SHEET 1 OF 5
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR THE PURPOSE OF DESIGN, CONSTRUCTION OR OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- A NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: 42.00 lbs APPROX
 9) MASK ALL HOLES PRIOR TO POWDER COATING

8 7 6 5 4 3 2 1

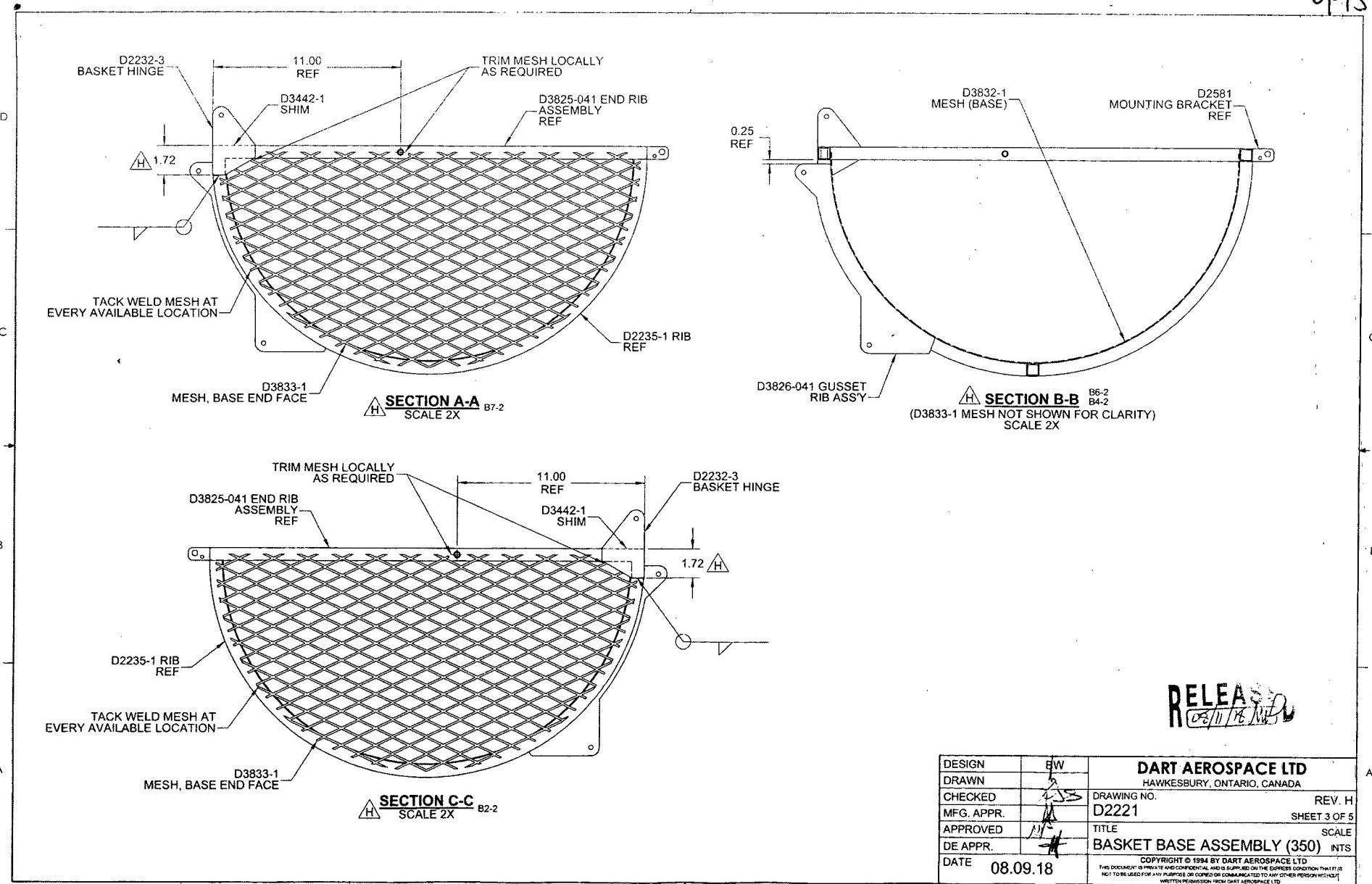
99542



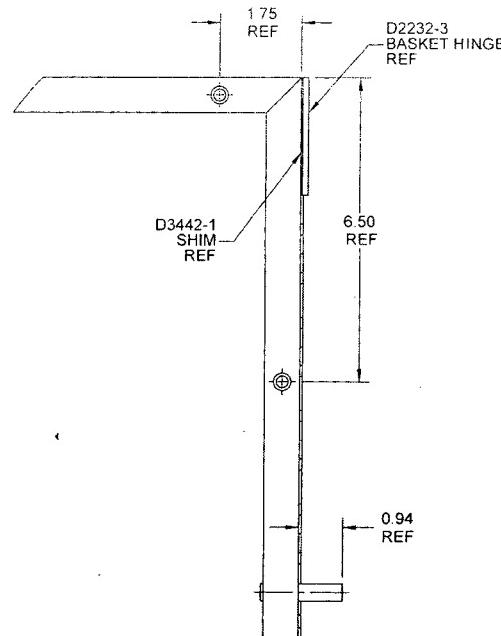
D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>JAS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>JA</i>	D2221	SHEET 2 OF 5
APPROVED	<i>WT</i>	TITLE	SCALE
DE APPR.	<i>WT</i>	BASKET BASE ASSEMBLY (350) NTS	
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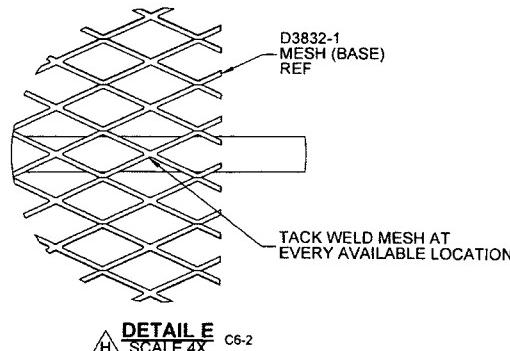
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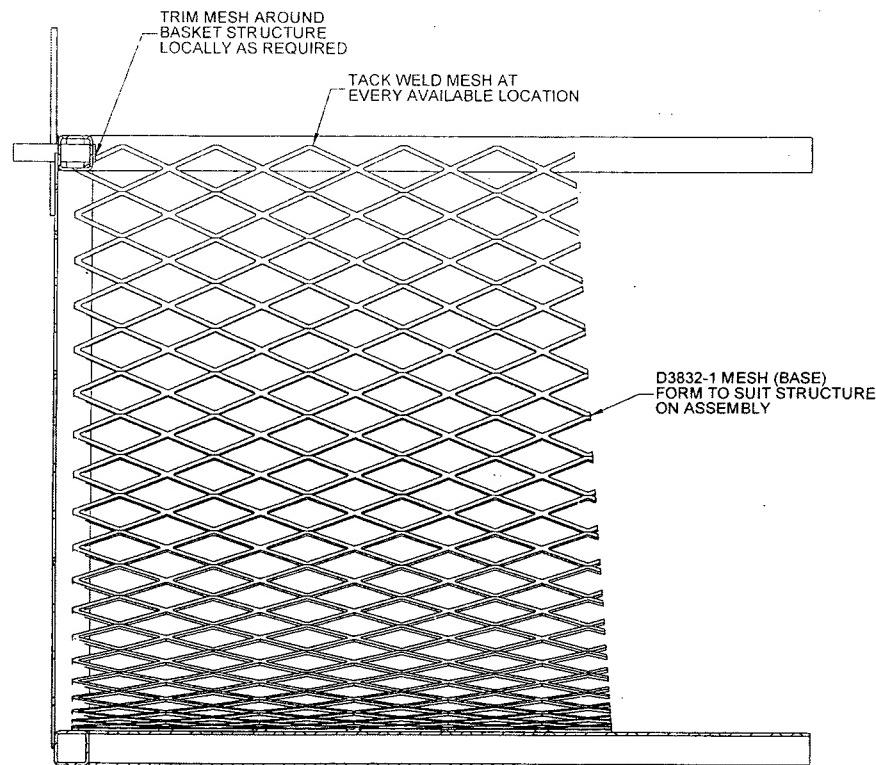
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DETAIL D D2-2
SCALE 4X



DETAIL E C6-2
SCALE 4X

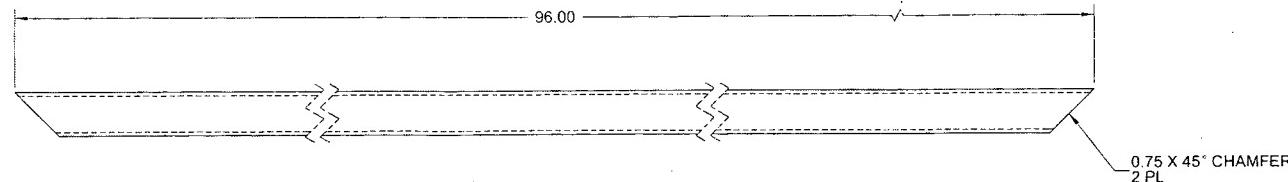
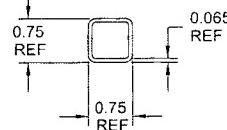
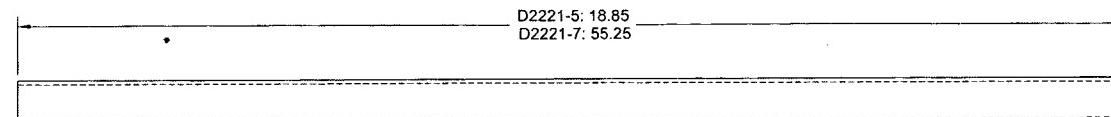
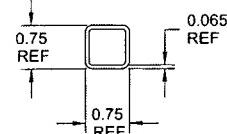


SECTION F-F D7-2
SCALE 4X

RELEASED
08/11/18 MHD

DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	M/S	DRAWING NO.
MFG. APPR.		D2221
APPROVED		REV. H
DE APPR.		SHEET 4 OF 5
DATE	08.09.18	TITLE
		BASKET BASE ASSEMBLY (350) NTS
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99542

**D2221-1 RIB****D2221-5/-7 RIB**

A	B	C	D
NOTES:			
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065			
2) FINISH: NONE			
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED			
4) UNITS: INCHES UNLESS OTHERWISE NOTED			
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX			
6) IDENTIFICATION: N/A			
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs			

8 7 6 5 4 3 2 1

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>ND</i>	D2221	SHEET 5 OF 5
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	BASKET BASE ASSEMBLY (350) NTS	
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06/11/18 MM